



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

JUN 21 2018

D205-633-022
Job Sheet 179714



004250

Part No: D205-633-022

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Simplex Tank Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C SHEET 17 IPP Rev:B Added D2565-111 05-09-09 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Stores/Pkg-1		JUL 06 2018
110	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging1-2		JUL 08 2018
120	QC	1 pcs	7/13/18	7/13/18	0.00	0.00	QC4		JRB 28
130	Packaging	1 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-1		SRB 288
135	DC	1 pcs	7/13/18	7/13/18	0.00	0.00	DC		JRB 288
140	QC21-FG	1 Ea	7/13/18	7/13/18	0.00	0.00	QC21		DAS 9-8-89
Part Op 130 - Identify and pack for shipping as per PPP D205-633-021 Location : FG082 Descriptions: 135 - Photocopy bluefile & type labels per PPP D205-633-022 CHG001									21 JUL 10 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-11A	Bolt	1 Ea (1 ea)	90-Start up Operation	5070193
AN4-14A	Bolt	1 Ea (1 ea)	90-Start up Operation	5067888
AN4-5A	Bolt	1 Ea (1 ea)	90-Start up Operation	5027725
AN4-6A	Bolt	4 Ea (4 ea)	90-Start up Operation	5058982
AN4-7A	Bolt	1 Ea (1 ea)	90-Start up Operation	5057520
AN44-7A	Eyebolt	1 Ea (1 ea)	90-Start up Operation	5063249
AN5-14A	Bolt	1 Ea (1 ea)	90-Start up Operation	5056344
D2022-101	Spacer	4 Ea (4 ea)	90-Start up Operation	5071656
D2022-103	Spacer	2 Ea (2 ea)	90-Start up Operation	5071112
D2562-011	Strut 25.79"	1 Ea (1 ea)	90-Start up Operation	5074498
D2565-101	Strut	1 Ea (1 ea)	90-Start up Operation	5076843
D2565-103	Strut	1 Ea (1 ea)	90-Start up Operation	5076882
D2565-105	Strut	1 Ea (1 ea)	90-Start up Operation	5077805
D2565-107	Strut	1 Ea (1 ea)	90-Start up Operation	5052878
D2565-109	Strut	1 Ea (1 ea)	90-Start up Operation	5076989
D2565-111	Strut	1 Ea (1 ea)	90-Start up Operation	5074852
D3437-041	Aft Strut Assembly	1 Ea (1 ea)	90-Start up Operation	5069662
D3438-042	Weldment Assembly	1 Ea (1 ea)	90-Start up Operation	5062209
MS21042L4	Nut	8 Ea (8 ea)	90-Start up Operation	5022240x3 5075983x1 502386x1
MS21042L5	Nut	2 Ea (2 ea)	90-Start up Operation	5058178
NAS1149D0463J	Washer	16 Ea (16 ea)	90-Start up Operation	5067900x8 5062379x8
NAS1149D0563J	Washer	3 Ea (3 ea)	90-Start up Operation	5068662

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Cross tube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																	
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Date : _____ Step #: _____		MRB (QSI042) Approval																		
Description Work Order																				
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S090119 Part: D205-633-022 Job No: 179714 Serial No/Batch: S090119 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/09/18		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																		
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%;"> <tr> <td style="width: 33%;"> Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 33%;"> Broken/Damage/Detect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width: 33%;"> Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>			Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Detect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐											
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OTHER : _____		<table style="width: 100%;"> <tr> <td style="width: 50%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>			Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-11A	1	390	0
	AN4-14A	1	298	0
	AN4-5A	1	39	0
	AN4-6A	4	1,264	0
	AN4-7A	1	144	0
	AN44-7A	1	7	0
	AN5-14A	1	85	0
	D2022-101	4	35	0
	D2022-103	2	23	0
	D2562-011	1	7	0
	D2565-101	1	4	0
	D2565-103	1	4	0
	D2565-105	1	4	0
	D2565-107	1	6	0
	D2565-109	1	4	0
	D2565-111	1	5	0
	D3437-041	1	1	0
	D3438-042	1	2	0
	MS21042L4	8	2,313	0
	MS21042L5	2	558	0
	NAS1149D0463J	16	4,030	0
	NAS1149D0563J	3	1,919	0
			Stok!	

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART AEROSPACE LTD.

IIN-D205-633

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**5.2 D205-633-021/-022/-023/-024/-025/-026 Heli-Access Step
(Simplex Model 304 Fire Attack Tank Compatible)**

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
				*1	*1	D3165-1	SUPPORT ARM
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

* ONLY INSTALLED IF TANK IS REMOVED

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Revision: C

Date: 13.12.13